

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018025**Date Inspected:** 10-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	An Qing Xing		
<b>Inspected CWI report:</b>	Yes	No	N/A
<b>Electrode to specification:</b>	Yes	No	N/A
<b>Qualified Welders:</b>	Yes	No	N/A
<b>Approved Drawings:</b>	Yes	No	N/A

<b>CWI Present:</b>	Yes	No
<b>Rod Oven in Use:</b>	Yes	No N/A
<b>Weld Procedures Followed:</b>	Yes	No N/A
<b>Verified Joint Fit-up:</b>	Yes	No N/A
<b>Approved WPS:</b>	Yes	No N/A
<b>Delayed / Cancelled:</b>	Yes	No N/A
<b>Component:</b>	OBG COMPONENT	

**Bridge No:** 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Outside Yard

This QA Inspector observed the following work in progress:

FCAW in the 1G position for the OBG segment 11BW, weld No.OBW11-027.The welder is identified as #049220. ZPMC QC is identified as Mr. Zho Zhong Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2231-Tc-U4b-F2.

FCAW in the 2G position for the OBG segment 11EW light bracket, weld No.LB3-004-044.The welder is identified as #040609. ZPMC QC is identified as Mr. Zho Zhong Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2332-Tc-P4-F-1.

FCAW in the 2G position for the OBG segment 11AW light bracket, weld No.LB3-003-044.The welder is identified as #053486. ZPMC QC is identified as Mr. Zho Zhong Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2332-Tc-P4-F-1.

SMAW in the 4G position for the OBG segment 11DW to 11EW, weld No.OBW11C-007.The welder is identified as #046709. ZPMC QC is identified as Mr. Zhou Peng. The welding variables recorded by QC appear to comply with WPS-B-P-2214-B-U2-FCM-1.

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SMAW in the 3G position for the OBG segment 11DE to 11EE, weld No.OBE11A-006.The welder is identified as #053871. ZPMC QC is identified as Mr. Shi Lei. The welding variables recorded by QC appear to comply with WPS-B-P-2213-B-U2-FCM-1.

Ultrasonic Testing (UT) for Crossbeam CB19 at Bay#7

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as OBG crossbeam CB19 weld joints.

The welds designation reviewed are as follows:

CB3003D-019-001,002

CB3003F-019-001,002

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

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No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Bera,Subhasis	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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